

# Work Order ID 110115

December-17-13 9:15:26 AM

\*110115\*

Page 1

Item ID: D3914-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Long Basket Lid Assembly (350)  
 Start Date: 12/17/13 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 12/17/13 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12-12-19 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3914	C
D4020	A

100 Weld per dwg A/R S.S. rod Batch: B/23823 0.00  
 Large Fab  
 \*100\*  
 Large Fab  
 Large Fab  
 Memo 0.00  
 1- assemble ribs, weld as per dwg D3914 using DT9607A  
 2- weld hinge (3) and Mounting brackets as per dwg D3914  
 \*\*\*Visual inspect before welding mesh\*\*\*  
 3- tack weld mesh on basket as per dwg D3914  
 \*\*\*Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh\*\*\*

1x CC 14-1-17

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00  
 \*110\*  
 QC Memo 0.00  
 Quality Control

① 14-01-17 DAS  
 9  
 9-89

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Page 2

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									DAS
QC	Memo	0.00						① 14-01.17	9
Quality Control									9-89
130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
<b>*130*</b>									DAS
Powdercoat	Memo	0.00						1 of 14-1-20	34
Powder Coating	*** mask sides of hinge prior to powdercoat***								9-89
	Start Time: 8:35								
	Oven Temperature: 320°								
	Finish Time: 9:05								
140	Wing Walk as per dwg QSI005 4.4 Batch _____	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00						1x of 14-1-20	
Hand Finishing	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg								
	2- Install placard and label as per dwg								
	***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label***								

December-17-13 9:15:26 AM

Page 3

0.00

1 Min 14.01.20

12 of 92 11/10/20

                 R 14-01-22

~~M~~ 14-01-21

# Picklist Print

December-17-13 9:15:23 AM

Page 1

Work Order ID: 110115

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD  
10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD VERF:JLM  
IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3914-1 Rib		Manufactured	No			100	Each	8.0000	2	2		CC 14-1-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		8							
				105977		8			(2x)				
D3914-7 Rib		Manufactured	No			100	Each	6.0000	2	2		CC 14-1-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		6							
				107271		6			(2x)				
D4018-5 Rib		Manufactured	No			100	Each	24.0000	9	9		CC 14-1-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		24		B107231	(9x)				
				100347		3							
				104988		18							
				106726		3							
D4035-043 Lid Rib Assembly, Aft (350 Basket)		Manufactured	No			100	Each	2.0000	2	2		CC 14-1-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		2		B110120	(2x)				
				107509		1							
				108589		1							

# Picklist Print

December-17-13 9:15:23 AM

Page 2

Work Order ID: 110115

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00



D2581  
Mounting Bracket

Manufactured No

100 Each 264.0000 2 2

CC 14-1-14

Location

Loc Qty

Loc Code

WA004

264

102265

94

103683

98

105886

48

107768

24

(2x)

D4016-3  
Hinge Half, Lid

Manufactured No

100 Each 43.0000 3 3

CC 14-1-14

Location

Loc Qty

Loc Code

WA004

43

103029

23

106882

20

(3x)

D4020-5  
Mesh (350 Basket Long, Lid)

Manufactured No

100 Each 1.0000 1 1

CC 14-1-14

Location

Loc Qty

Loc Code

WA004

1

107300

1

B1102ZZZ →

(1x)

D4021-3  
Data Plate

Manufactured No

100 Each 27.0000 1 1

CC 14-1-14

Location

Loc Qty

Loc Code

WA004

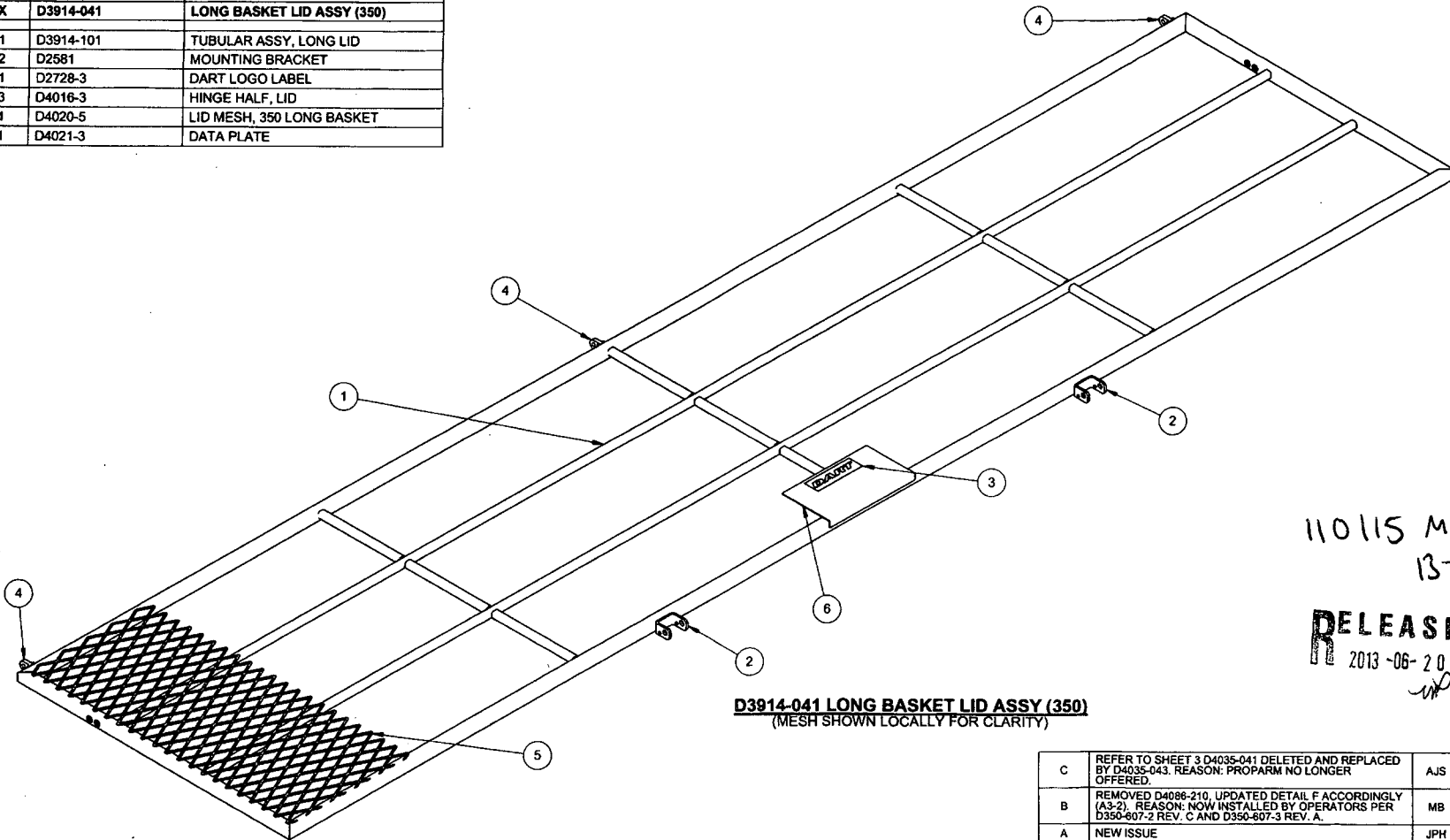
27

101346

27

(1x)

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
5	1	D4020-5	LID MESH, 350 LONG BASKET
6	1	D4021-3	DATA PLATE



**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

110115 MJS  
13-12-19

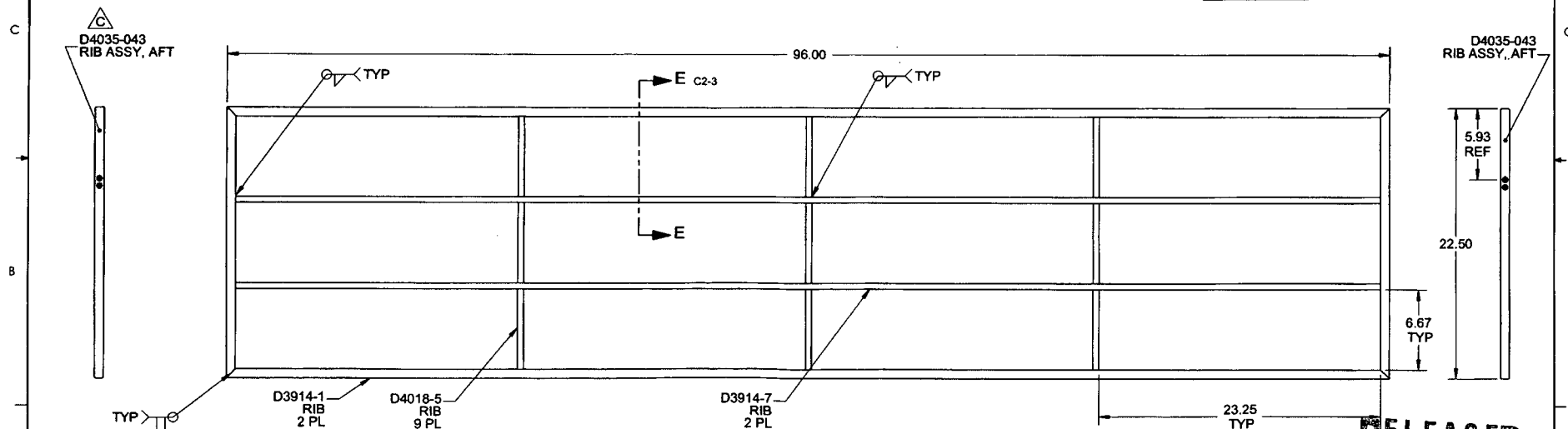
**RELEASED**  
2013-06-20  
WJD

C	REFER TO SHEET 3 D4035-041 DELETED AND REPLACED BY D4035-043. REASON: PROPARM NO LONGER OFFERED.	AJS	13.03.13
B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO. <b>D3914</b> REV. C	
MFG. APPR.	JS		
APPROVED	JS	TITLE <b>LONG BASKET LID ASSY (350)</b> SCALE NTS	
DE APPR.	JS		
DATE	13.03.13	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHEN SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	2	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



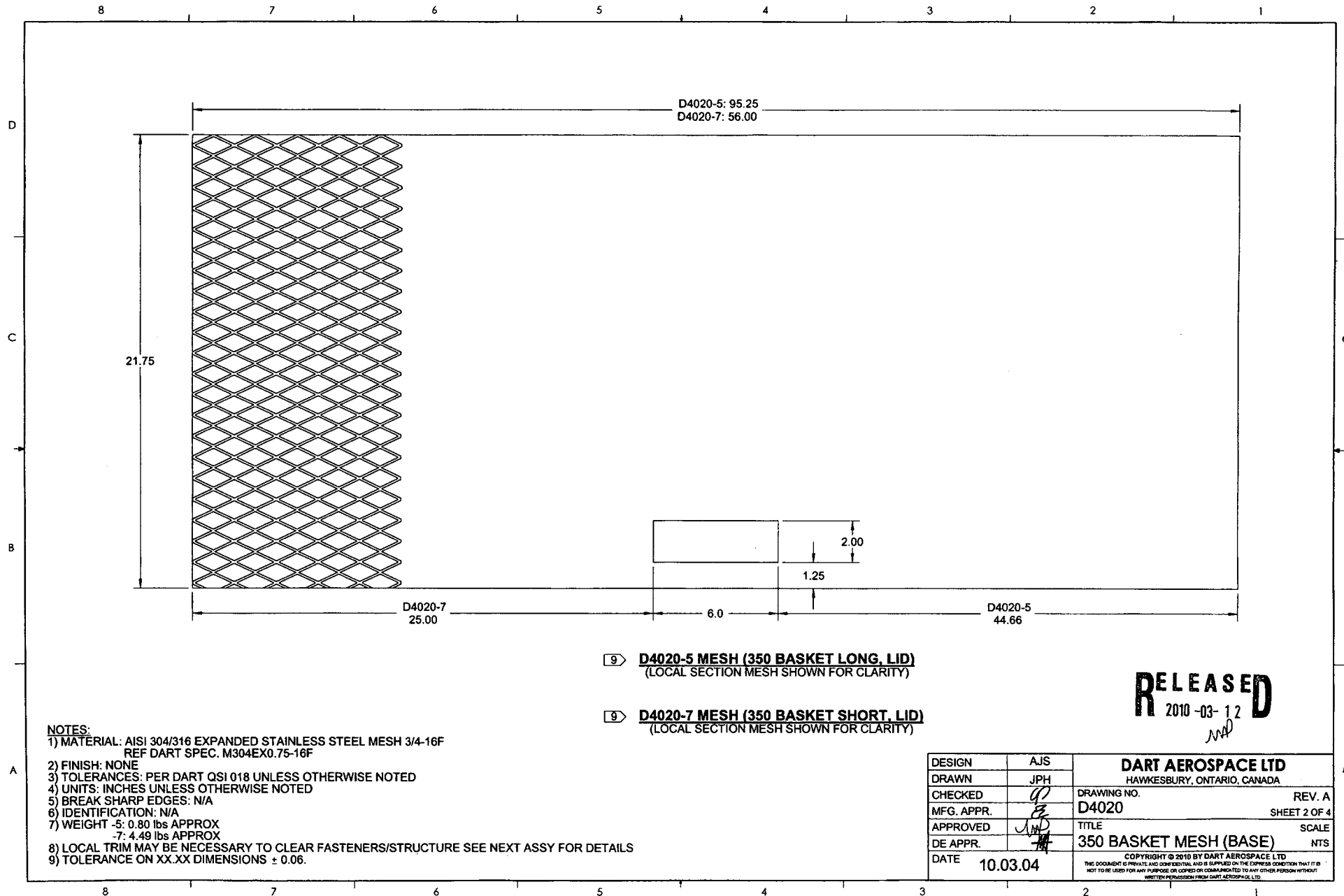
⑧ D3914-101 TUBULAR ASSY, LONG LID

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3914-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	IS	D3914	SHEET 3 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	HA	LONG BASKET LID ASSY (350)	NTS
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RELEASED  
2013-06-20



**RELEASED**  
 2010-03-12  
*[Signature]*